

Work Order ID 63273



Page 1

Wednesday, October 27, 2010 9:07:21 AM

Item ID: D212-725-1-157F

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Angle Oil Cooler

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-725-1	E								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: F

2024 .040

2-Deburr if necessary

B10-10-28

3

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 10/10/28

(X3)

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 10/10/28

(3)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/10/28

(2)

W/O:		WORK ORDER CHANGES					
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Page 3

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Revision ID:

Item Name: Support Angle Oil Cooler



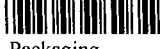
Start Date: 10/27/2010 Start Qty: 2.00

Required Date: 11/30/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				3		10-10-28	
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				3			
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>385</u> Memo	0.00 0.00							

=> 10/10/28

385 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 J

MF
10-10-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 9:07:26 AM

Page 1

Work Order ID: 63273



Parent Item: D212-725-1-157F



Parent Item Name: Support Angle Oil Cooler

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

315.6400

0.5869

1.235579



1810-10-28

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT

78.1

114415

78.1

MAT22

237.54

110305

21.93

111786

13.76

112291

28.25

112331

52

113162

121.6

111786

②

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D212-728-1-157F

X	First Article	X	Prototype
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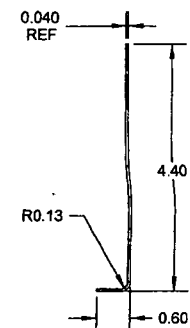
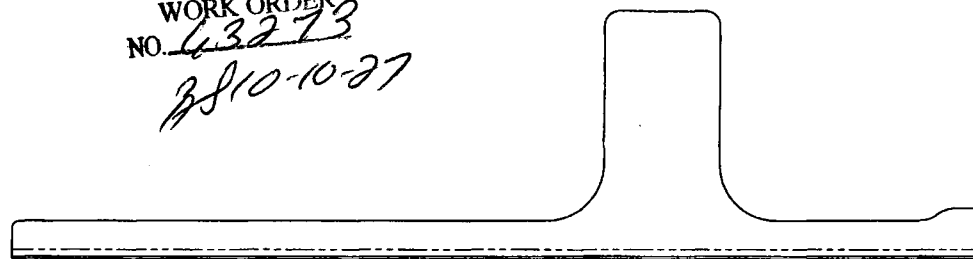
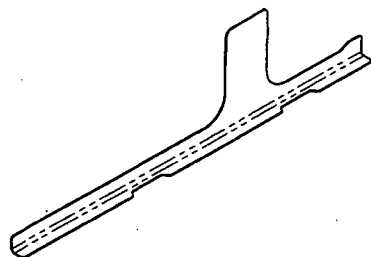
Measured by:	18	Audited by:	S	Prototype Approval:	
Date:	10-10-20	Date:	10/10/20	Date:	

H:\FORMS\Quality Assurance\approved QA\FAI revD

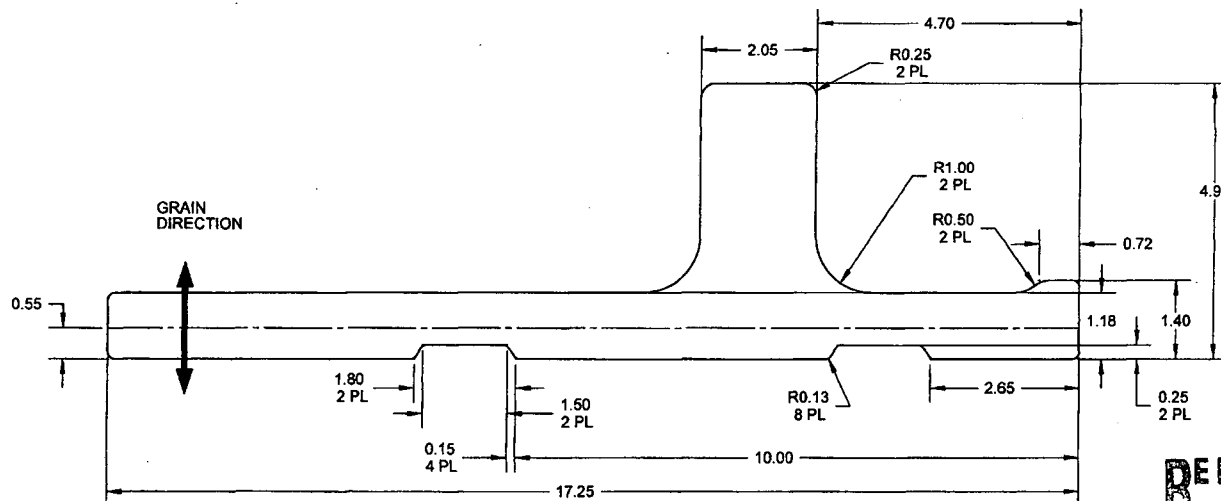
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT


WITHOUT NOTICE
WORK ORDER
NO. 43273

2810-10-27



D212-725-1-157 ANGLE
(MAKE FROM D212-725-1-157F)





 D212-725-1-157F FLAT PATTERN

RELEASED
2009-10-28
MM

NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D212-725-1	SHEET 53 OF 82
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	08.09.17	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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